



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 186233



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		NOV 28 2018 Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/10/18	12/10/18	0.00	0.00	Start Up Stores/Pkg-1		DEC 12 2018
110	Packaging	1 pcs	12/10/18	12/10/18	0.00	0.00	Packaging1-1		DEC 19 2018
120	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC4		DEC 19 2018
130	Packaging	1 pcs	12/10/18	12/10/18	0.00	0.00	Packaging3-1		DEC 27 2018
135	DC	1 pcs	12/10/18	12/10/18	0.00	0.00	DC		DEC 27 2018
140	QC21-FG	1 Ea	12/10/18	12/10/18	0.00	0.00	QC21		DEC 27 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5135807
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5135806
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5136259
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5119441
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5119256
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5117183
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5119224
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5081641
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	8063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5072241
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5003766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5082442
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5063780
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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2

646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5063754
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5118787
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5070843
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	513686
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5073258
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	51243772. 51268542.
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5128109
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5641498
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5097197
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5128124
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5122789
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5130322
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5131193
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5112901
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080627
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5104032
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5131214
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5103962
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5108525
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	514134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	5124089
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5166409
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5109736
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5103943
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5118346
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5071834
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	500097121
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5104364
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5131198
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5104011
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5131201
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5123456
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5107796

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	216	0
	600.0990	1	10	0
	600.0991	1	10	0
	600.1012	1	23	0
	600.1013	5	62	0
	646.2910	1	23	0
	646.3001	1	12	0
	646.3110	1	10	0
	646.3210	1	12	0
	646.3301	1	10	0
	646.3510	1	15	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTV Effective : _____ MRB (QSI042) Approval _____

Description Work Order

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S137008

Part: 646.4001

Job No: 186233

Serial No/Batch: S137008

Revision:

Inspector:

Exp Date: 05/11/2019

Instructions: FAA STC SR02180LA 14/08/07, 16/07/16, STC SH09 -

Completed By _____

Lead hand / Supervisor
Approval Verification _____

QC / QA Coordinator
Approval _____

Root Cause

Environment ☐	No Re-verification ☐	Cracks ☐	Inspection Incomplete/unclear ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Crimp/Kink/Ripple/Wave ☐	Contamination ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Cuffs ☐	Countersink ☐	Over/Under tolerance ☐
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Substation ☐	Process Improvement ☐			Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐			
Misidentified ☐	Past Due ☐	OTHER : _____		

646.3511	1	20	0
646.3610	1	20	0
646.3710	1	46	0
646.3711	1	30	0
646.3712	1	18	0
646.3713	1	25	0
646.3714	1	19	0
646.3715	2	25	0
646.3716	1	36	0
646.3717	1	22	0
646.3718	2	36	0
646.3719	2	28	0
646.3810	2	15	0
646.3811	1	27	0
646.3812	2	8	0
646.3813	1	9	0
646.3910	4	63	0
646.3911	1	19	0
646.3912	4	61	0
646.3913	1	35	0
646.9410	1	97	0
647.0112	2	80	0
647.7703	2	8	0
650.9201	2	29	0
AN3-11A	10	135	0
AN3-12A	2	88	0
AN3-13A	1	95	0
AN3-3A	4	166	0
AN3-4A	10	334	0
AN3-5A	2	312	0
AN3-6A	2	176	0
AN316C4R	2	31	0
AN44-5A	2	25	0
AN4C7A	2	137	0
AN665-34R	2	23	0
CCR264SS3-02	36	527	0
CR3213-5-3	14	232	0
MS20426AD5-7	2	986	0
MS20470AD5-5.5	8	218	0
MS20470AD5-6	8	1,001	0
MS20470AD5-7	3	134	0
MS21042L08	2	1,559	0
MS21042L3	63	1,952	0
MS21042L4	2	2,046	0
MS21047-3	18	424	0
MS24693-C278	5	134	0
MS24694-S51	5	290	0
MS24694-S54	2	404	0
MS24694-S55	3	95	0
MS27039-08-13	2	576	0
MS27039-1-10	2	252	0
MS27039-1-12	6	240	0
MS27039-1-16	24	549	0
MS27039-1-19	22	307	0
MS27039-1-20	2	97	0
MS27039-1-21	4	106	0
NAS1149F0332P	144	1,657	0
NAS1149F0363P	2	549	0
NAS1149F0432P	4	702	0
NAS1149FN832P	4	2,415	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					